

Date: Wednesday, 3/8/2006 10:38:24 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HORIZONTAL TUBE
Job Number : 26120	
Estimate Number : 12313	
P.O. Number : N/A	Part Number : D34737
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : D3473 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <i>See comment below</i>	Due Date : 3/31/2006 Qty: <i>10</i> Um: Each
Checked & Approved By : <i>06-03-08</i>	
Comment : Est Rev: A New Issue 06-03-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: *00000768* *06/03/09*
E-mail or Ship DXF file to vendor
Laser cut flat pattern as per Dwg D3473
Possible supplier: Ind. Laser
Material release note is required.

2.0	D34737F	HORIZONTAL TUBE FLAT PATTERN
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Comment: Qty.: 1.0000 sf(s)/Unit Total : *6.0000* sf(s)
FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

Spot weld 2 then
2-Roll & Bead as per Dwg D3473

304/316 SS MIL-S-5019 Batch: M19704

made by Rand

SB 06/04/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One labor per template		12/03/29	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 12/04/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/26		Slot pattern from laser cut wrong dims		Scrap 10 pieces replace with 5 made by hand Scrap template				

NOTE: Date & initial all entries

Date:
User:

Wednesday, 3/8/2006 10:38:25 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HORIZONTAL TUBE

Job Number: 26120

Part Number: D34737

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Spot weld as per Dwg D3473

6.0

QC59/

WELD INSPECTION



Comment: WELD INSPECTION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Job Completion



Level 21 inspection

AD 06-04-25 (5)
06/04/27
U 06-04-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

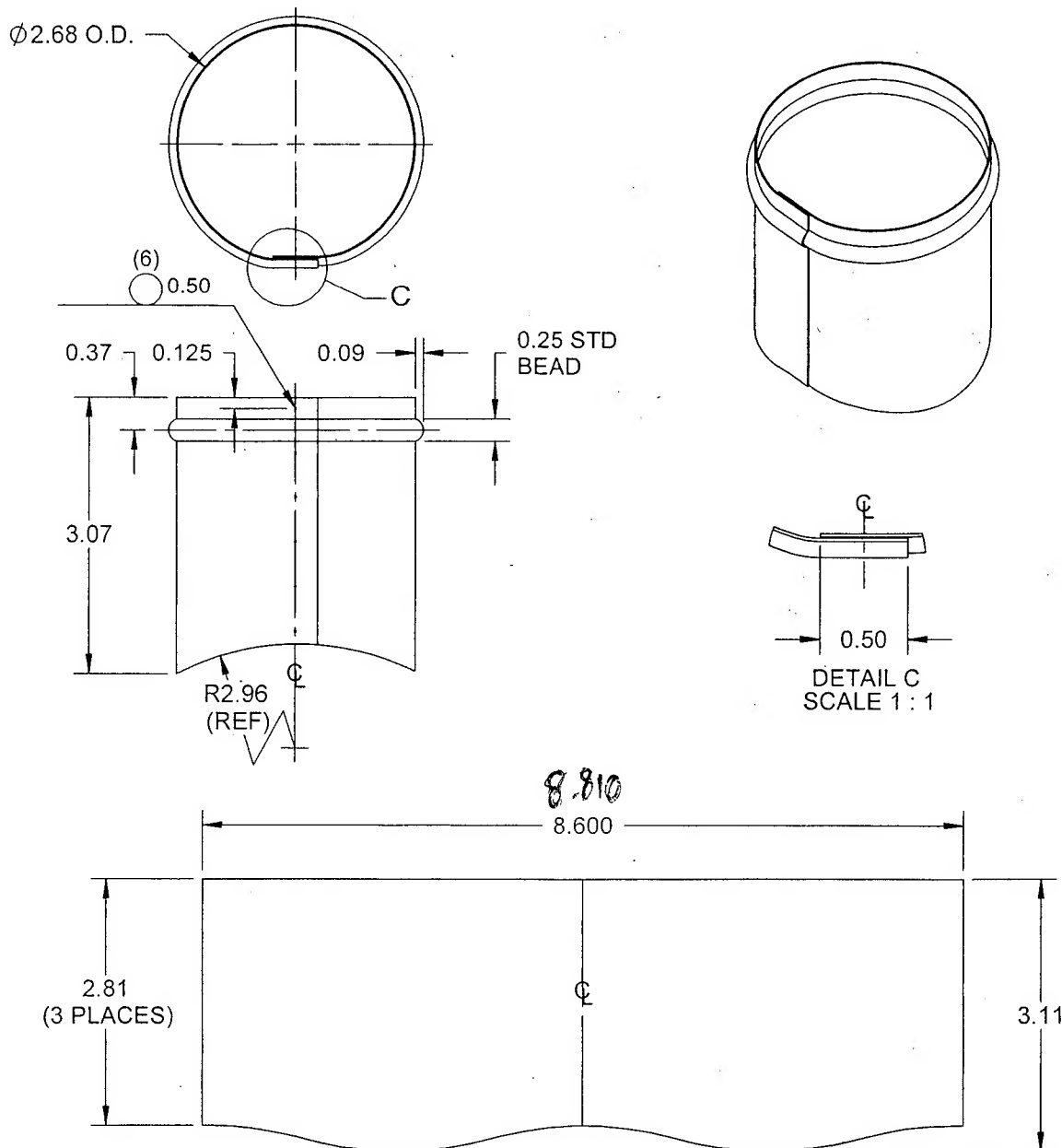
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. A SHEET 6 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-7F HORIZONTAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010


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002
001/004

INDUSTRIAL LASER P.O. - 110880 S.O. - 374786 ITEM 01 - 3 SHES

3/13/06
604-946-453
ATTN: JETE

		INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440		INTEGRIS METALS 306 B STREET ALBANY, WA 98001		EXHAUST UNITS - PRODUCT - 41000 X COIL 41000 X COIL	
AK Steel Corporation Metallurgical Test Report Coaction Works Coaction, OH 43812		Lead No. 710672 SRN No. 710672		MILL ORDER NO. PROCTESSOR ORDER NO. 771067-01 427135-01		PART NO. 4451491 771067-01 427135-01	
Fig 1				BUYERS ORDER NO. 427135-01			

[illegible]

REMARKS	NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR THE ALLOYS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL

PRODUCT DESCRIPTION

[illegible]

PARENT CO.	SQ	MR	COND	2 INCH S LONG	TENILE STRENGTH	% OSTE % OSTE	ROCKWELL HARDNESS	ROCKWELL HARDNESS	ID
	(R)	(L, I, D)		(R)	(R)	(R)			

CONTINUED ON NEXT PAGE

Fax Server

F-537

03/17/2006 14:18 FAX 6042729137

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K9
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CROWN MEAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUELPH, ONT. K123
Control #: SC60214
Part #: 74271441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA LASH

TO 110880

S/P 90-374786 - 02

Edg 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.